

Date: Thursday, 07/12/2006 3:12:25 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : D209-669-041

Job Number : 29844

Estimate Number : 10804

P.O. Number :

Part Number : D209669041

This Issue : 07/12/2006 S.O. No. :

Drawing Number : REWORK-NCR083

Prsht Rev. : NC

Project Number :

First Issue : 11 Type : LANDING GEAR

Drawing Revision :

Previous Run : 00015

Material :

Written By :

Due Date : 14/12/2006

Qty:

1 Um:

Each

Checked &amp; Approved By :

Comment :

Additional Product

Job Number :

Seq. #:

Machine Or Operation:

Description:

1.0

D209669041

Skidtube Assembly

Comment: Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Skidtube Assembly

B/N: 23780

2.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

DISASSEMBLE ALL HARDWARE;

1 X D2855 CAP

1 X D2577-3

1 X D2577-5

1 X D2577-1

12 X PLUGS

ALL BOLTS &amp; HARDWARE (DISCARD HARDWARE)

3.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

GRIND AND REMOVE PAINT AND ALODINE FROM AFT TOW RING HOLE INSIDE &amp; OUT

PLACE A COPPER BACKING ON THE INSIDE OF THE HOLE, AND FILL THE 0.640" WITH WELD-ON  
 BOTH SIDES OF TUBE

ALUM ROD

GRIND WELD FLUSH

FABRICATE (2) Aluminum Plugs TO PLUG THE HOLES  
 MATERIAL M104182

WELD IN PLACE PER QSI 004 AND GRIND FLUSH  
 ON BOTH INSIDE AND OUTSIDE OF TUBE

BE 07-08-08



Date: Thursday, 07/12/2006 3:12:25 PM  
User: Linda Lacelle

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D209-669-041

Job Number: 29844

Part Number: D209669041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC5/9

WELD INSPECTION



QCS for 08-08  
QCA PS 08-02-20



Comment: WELD INSPECTION

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

-TOUCH UP REWORKED ARE WITH ALODINE AS NECESSARY

-ENSURE TUBE IS CLEAN AND FREE OF ANY MARKINGS BEFORE POWDER COATING

-POWDER COAT TUBE AS PER QSI 005 4.3.5.1 WHITE

FL 08/02/20 (1)

M107005

08-02-20 (X)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 08/02/20

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

-INSPECT FOR FOREIGN OBJECTS

-ASSEMBLE TUBE AS PER DRWG D2906

USE ORIGINAL CAP, WEARPLATES AND PLUGS

CAP B35663 (2X)  
O-rings B27168 (12X)

M-1 08/02/20

8.0

ALS41032130

Insert



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Insert

OR ALS71032-130

N/A 08-02-20

9.0

AN34A

Bolt



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Bolt

M104817

M-1 08/02/20

Date: Thursday, 07/12/2006 3:12:25 PM  
User: Linda Lacelle

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D209-669-041

Job Number: 29844

Part Number: D209669041

Job Number:



Seq. #:

Machine Or Operation:

Description:

10.0

AN960JD10L

Washer



Comment: Qty.: 54.0000 Each(s)/Unit Total: 54.0000 Each(s)  
Washer

M104885

M/L

11.0

AN35A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Bolt

M100188

M/L

12.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Washer

M104885

M/L

SIKAFLEX 291 B

M105585

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M106894

(IX)

WING WALK AS PER DRWG

M/L

08/02/21

14.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

(PTO)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REPACKAGE PER PPP  
USING NEW B/N & NEW CHG NUMBER  
NEW PAPERWORK AND LABELS REQUIRED.

16.0

QC21

FINAL INSPECTION/W/O RELEASE



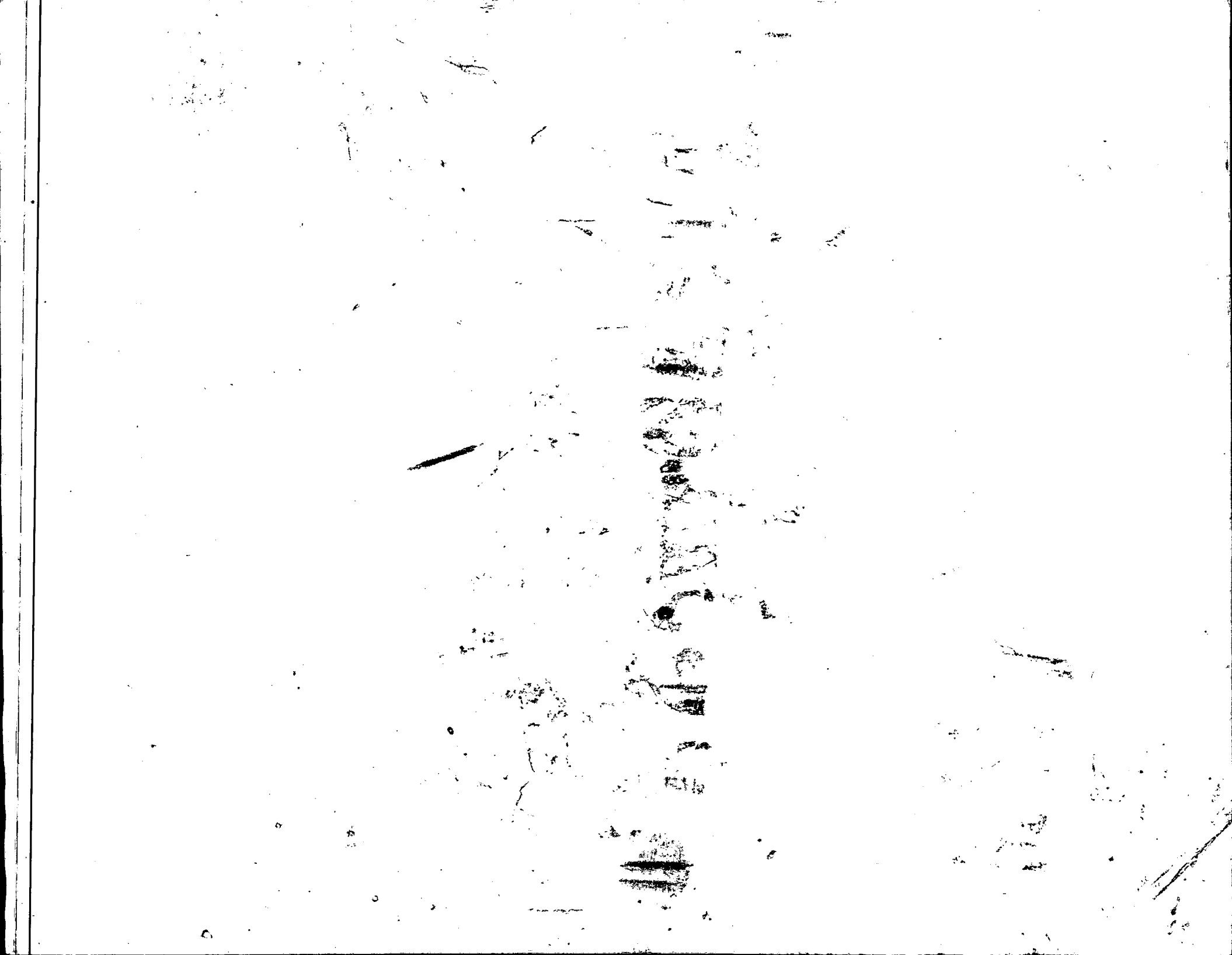
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



2008/3/14

(O)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D257-489-041 PAR #: N/A Fault Category: Prod / Landing Gear NCR: Yes No DQA: D Date: 08/03/14  
 QA: N/C Closed:        Date:       

NCR: <u><del>75844</del> 003</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/20	7.0	Scrap cap's forward and aft	<i>[Signature]</i>	REWORK - NCR 083 replace 2x D2855 cap B 35663	<i>[Signature]</i> 08/02/20	<i>[Signature]</i> 08-02-20	<i>[Signature]</i>	<i>[Signature]</i> 08-02-20
08-03-12	7.0	This ring hole in the wing and of the skid. Due to multiple re-work, now another tube is scrap.	<i>[Signature]</i>	Disassemble and restock of I.D. the following: 2x D2855 B 35663 1x D2577-1 B 22142 1x D2577-3 B 22170 1x D2577-5 B 22970 - SCRAP	<i>[Signature]</i> 08-03-12	<i>[Signature]</i> 08-03-12	<i>[Signature]</i>	<i>[Signature]</i> 08-03-12
		P.C. Re-work was done to the incorrect location, incorrect re-work Eng. sketch supplied.	<i>[Signature]</i>	12x D2577-1 B 22143 Discard all hardware. Scrap & destroy tube.	<i>[Signature]</i> 08-03-13	<i>[Signature]</i> 08-03-13	<i>[Signature]</i>	<i>[Signature]</i> 08-03-12

NOTE: Date & initial all entries

